

Work Order ID 114039

March-03-14 12:40:39 PM

split
114039

Page 1

Item ID: D3649-041

Revision ID:

Item Name: Tunnel Bottom Panel Assy

Start Date: 3/03/14 Start Qty: 1.00

Required Date: 3/17/14 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: *MCJ*

Date: *14-03-03*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3649

Rev B

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3649 Dwg Rev: *B* Prog Rev: *B* 2-
Deburr if necessary

6 B 14-3-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 B 14-3-10

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

*DAS
27
9-95*

14/3/11

6

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Item ID: D3649-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tunnel Bottom Panel Assy
 Start Date: 3/03/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 3/17/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130				DAS		6			14/07/16
Brake NC	Memo	0.00		30					
Brake NC	Form as per Dwg D3649			9-89					
140	QC5- Inspect part completeness to step on W/O	0.00				6			
140									
QC	Memo	0.00							
Quality Control									
150	Small Fab	0.00				1X			14/07/22
150									DAS
Small Fab	Memo	0.00							36
Small Fab	1- Form dimple for MS20427M3 rivet per dwg D3649*****ensure dimples are on the proper side*****2-Assemble nutplates as per dwg D3649								9-89

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Item ID: D3649-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Tunnel Bottom Panel Assy

Start Date: 3/03/14 Start Qty: 1.00 *1*

Required Date: 3/17/14 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00				1x		14-7-22	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MCJ		14-07-22	

DAS
26
9-89

W1407.22

Picklist Print

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Work Order ID: 114039

114039

Parent Item: D3649-041

D3649-041

Parent Item Name: Tunnel Bottom Panel Assy

Start Date: 3/03/14

Required Date: 3/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-26 EC verified by: DD
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C Ecn1162 08-04-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S26GA		Purchased	No			150	sf	149.0000	6.069	7			
M304S26GA													
304/316 0.018 SHEET													

Location	Loc Qty	Loc Code
MAT020	149	
122753	26	
123135	123	

MS20427M3-3		Purchased	No			110	Each	882.0000	88	88			
MS20427M3-3													
Rivet													

Location	Loc Qty	Loc Code
GA	491	
121114	491	
ST335	391	
124231	391	

MS21060-3K		Purchased	No			150	Each	77.0000	22	22			
MS21060-3K													
Nut Plate													

Location	Loc Qty	Loc Code
ST316	77	
m126826	77	

Picklist Print

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Work Order ID: 114039

114039

Parent Item: D3649-041

D3649-041

Parent Item Name: Tunnel Bottom Panel Assy

Start Date: 3/03/14

Required Date: 3/17/14

Start Qty: 1.00

Required Qty: 1.00

MS21062-3K

Purchased

No

150

Each

142.0000

22

22

MS21062-3K

**

Nut Plate

14/07/18

08-6
98
DAS

Location

Loc Qty

Loc Code

GA

42

124316

42

ST317

100

124329

100

39
93

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Shop Packet Print

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DART AEROSPACE LTD		Work Order: 114039
Description: Tunnel Bottom Panel		Part Number: D3649-1
Inspection Dwg: D3649	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098	✓		U - Skmos	
Ø0.196	+0.005/-0.001	0.198	✓			
Ø0.250	+0.005/-0.001	0.255	✓			
0.400	+/-0.010	0.401	✓			
0.385	+/-0.010	0.386	✓			
0.250	+/-0.010	0.251	✓			
44.57	+/-0.030	44.57	✓		T Skmos	
11.70	+/-0.030	11.7	✓		"	
3.370	+/-0.030	3.370	✓		✓	
13.76	+/-0.030	13.75	✓			
4.300	+/-0.010	4.30	✓			
10.11	+/-0.030	10.115	✓			
12.90	+/-0.030	12.912	✓			
16.61	+/-0.030	16.615	✓			
15.80	+/-0.030	15.81	✓			
3.950	+/-0.010	3.952	✓			
0.42	+/-0.030	0.426	✓			
0.41	+/-0.030	0.415	✓			
0.85	+/-0.030	0.851	✓			
19.64	+/-0.030	19.642	✓			
0.54	+/-0.030	0.546	✓			
1.400	+/-0.010	1.407	✓			
2.63	+/-0.030	2.62	✓			
2.93	+/-0.030	2.93	✓			
1.49	+/-0.030	1.49	✓			
5.98	+/-0.030	5.98	✓			
0.54	+/-0.030	0.54	✓			
2.20	+/-0.030	2.20	✓			
2.75	+/-0.030	2.75	✓			
2.48	+/-0.030	2.48	✓			

DART AEROSPACE LTD		Work Order: 114035
Description: Tunnel Bottom Panel		Part Number: D3649-1
Inspection Dwg: D3649	Rev: B	Page 2 of 2

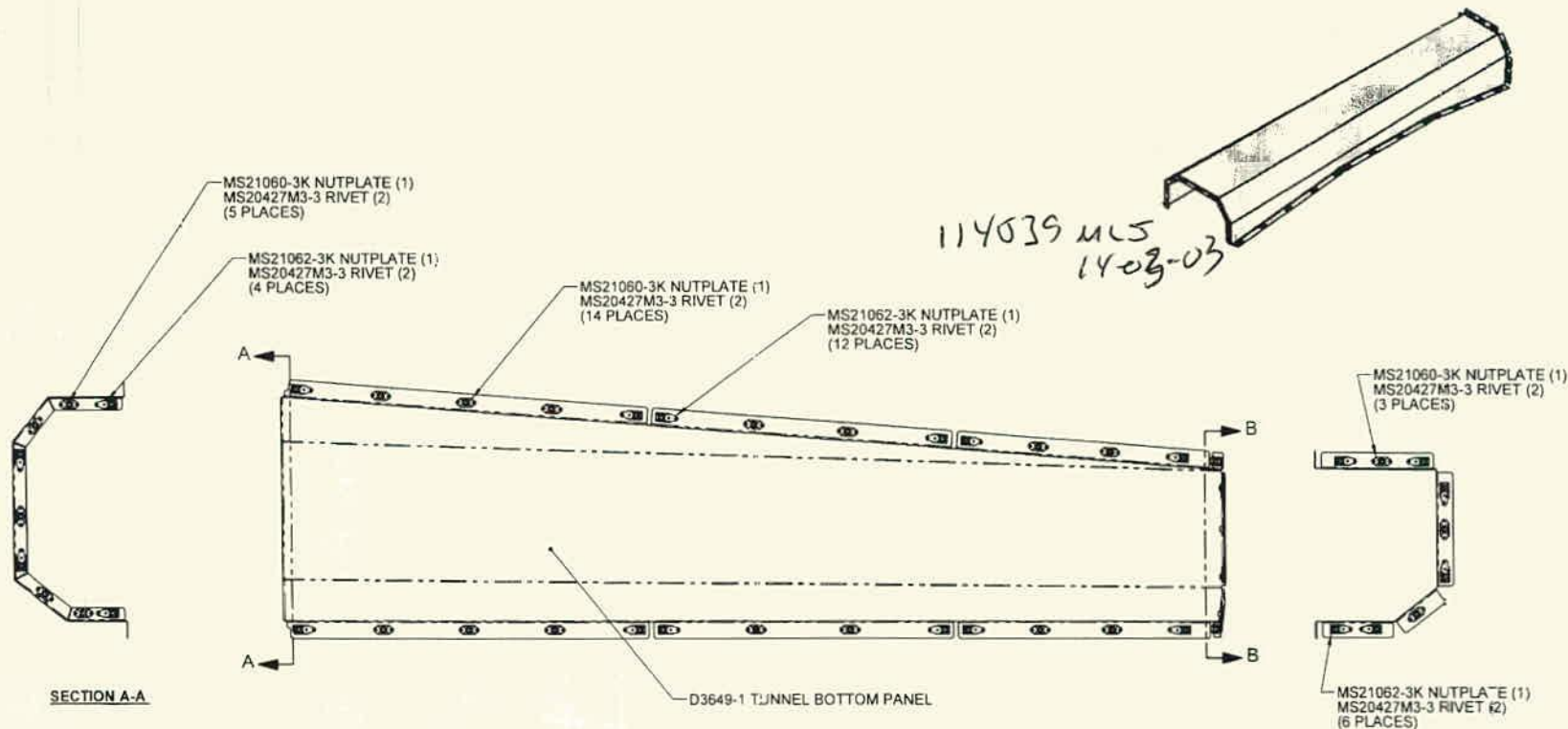
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.16	+/-0.030	1.16	✓			
3.38	+/-0.030	3.38	✓			
2.00	+/-0.030	2.00	✓			
0.90	+/-0.030	0.90	✓			
16.64	+/-0.030	16.64	✓			
0.48	+/-0.030	0.48	✓			
13.80	+/-0.030	13.8	✓			
0.46	+/-0.030	0.46	✓			
11.76	+/-0.030	11.76	✓			
1.23	+/-0.030	1.23	✓			
0.88	+/-0.030	0.88	✓			
18.46	+/-0.030	18.47	✓			
5.23	+/-0.030	5.23	✓			
1.932	+/-0.010	1.936	✓			
1.943	+/-0.010	1.944	✓			
5.02	+/-0.030	5.03	✓			
1.820	+/-0.010	1.825	✓			
0.70	+/-0.030	0.70	✓			
2.100	+/-0.010	2.110	✓			
2.33	+/-0.030	2.34	✓			
0.94	+/-0.030	0.95	✓			
3.30	+/-0.030	3.30	✓			
1.900	+/-0.010	1.9	✓			
0.61	+/-0.030	0.61	✓			

Measured by: <i>al</i>	Audited by: <i>DAS</i>	Prototype Approval:	N/A
Date: 14-3-10	Date: 14/3/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	<i>DD</i>



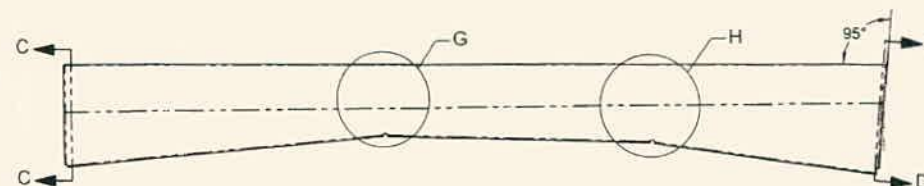
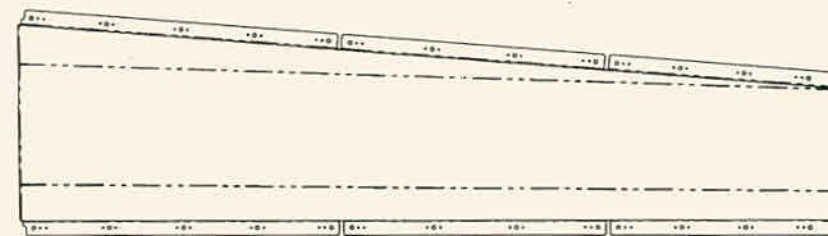
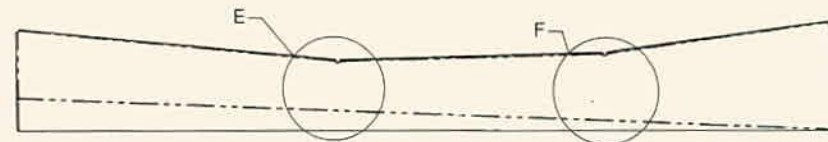
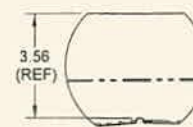
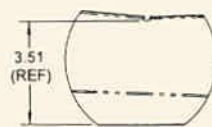
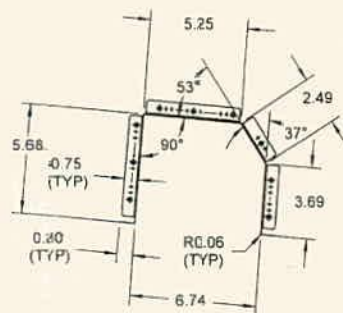
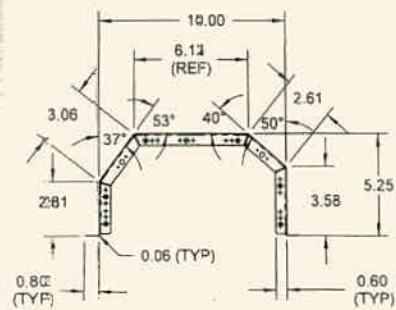
D3649-041 BOTTOM PANEL ASSEMBLY

PART LIST

QTY J41	PART NUMBER	DESCRIPTION
X	D3649-041	TUNNEL BOTTOM PANEL ASSY.
1	D3649-1	TUNNEL BOTTOM PANEL
88	MS20427M3-3	RIVET
22	MS21060-3K	NUTPLATE
22	MS21062-3K	NUTPLATE

B	PAGE 3: MS20427M3 WAS MS20427M-3	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	IE	DRAWING NO.	REV. B
MFG. APPR.	DC	D3649	SHEET 1 OF 3
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	BOTTOM PANEL ASSEMBLY	1:5
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

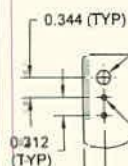
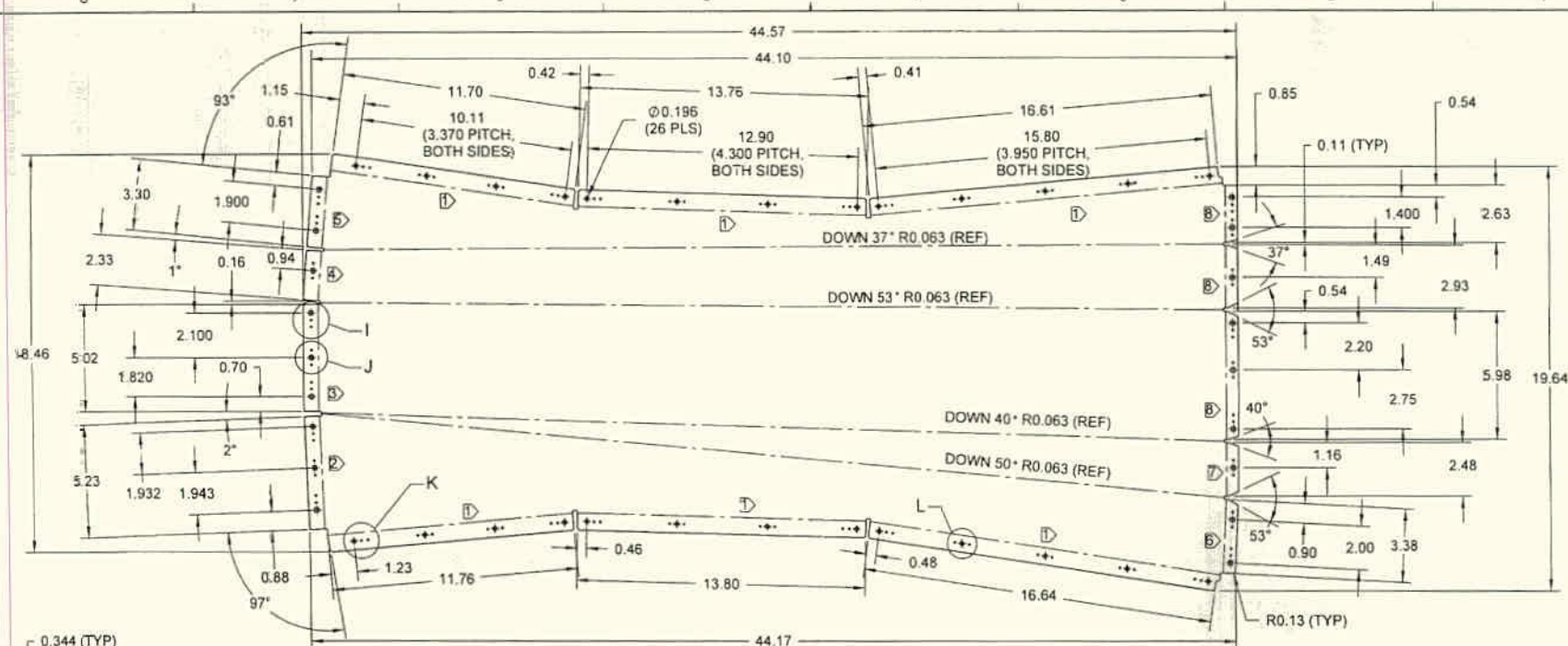
RELEASED
26-03-2010



D3649-1 TUNNEL BOTTOM PANEL
(MAKE FROM D3649-1F)

RELEASED
08-03-27

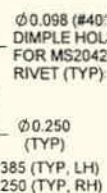
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3649	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BOTTOM PANEL ASSEMBLY	1:6
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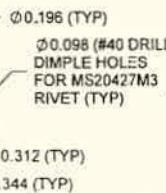
DETAIL I
(10 PLS)



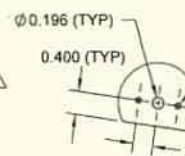
DETAIL J
(8 PLS)



DETAIL K
(12 PLS)



DETAIL L
(14 PLS)



- ① UP 90° R 0.063
- ② UP 94° R 0.063
- ③ UP 85° R 0.063
- ④ UP 87° R 0.063
- ⑤ UP 90° R 0.063
- ⑥ UP 94° R 0.063
- ⑦ DOWN 91° R 0.063
- ⑧ DOWN 90° R 0.063

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.32 lbs

D3649-1F FLAT PATTERN

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	DRAWING NO.	REV. B
MFG. APPR.	✓	D3649	SHEET 3 OF 3
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	BOTTOM PANEL ASSEMBLY	1:5
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	